

## Patent claims

1           1. A method of continuously casting metal or metal  
2 alloys, especially copper or copper alloys in which the liquid  
3 metal flows from a heating vessel through a casting nozzle into the  
4 casting pool of a continuous casting apparatus which is provided  
5 with a traveling mold, characterized in that the casting nozzle is  
6 configured as an immersion tube which projects into the casting  
7 pool formed by the traveling mold sides.

1           2. The method according to claim 1 characterized in that  
2 the immersion tube is matched in its inclination to the position of  
3 the melt level in the casting pool and is optionally controlled by  
4 feedback in response thereto.

1           3. The method according to claim 1 or 2 characterized in  
2 that the transport belts are slightly inclined with respect to the  
3 horizontal, preferably between 3° and 45° and/or have a spacing  
4 which is greater than 20 mm.

1           4. The method according to one of claims 1 to 3,  
2 characterized in that the liquid molten metal is transferred from  
3 the furnace directly into the immersion tube, preferably under  
4 pressure.

1           5. A casting device for the continuous horizontal  
2 casting of metal, comprised of a furnace (10), a device for  
3 transferring the liquid molten metal and a traveling mold,  
4 characterized in that the device for transferring the liquid molten  
5 metal is an immersion tube (13) which is movable along its  
6 longitudinal axis.

1           6. The casting device according to claim 5 characterized  
2 in that the immersion tube (13), preferably along its outer  
3 surface, has spacing sensors with which the relative position of  
4 the immersion tube to the casting pool can be adjustably  
5 controlled.

1           7. The casting device according to claim 5 or 6  
2 characterized in that the immersion tube is fixed directly with the  
3 casting furnace (10, 11) and that the furnace is movable along a  
4 path inclined to the horizontal so that the immersion tube (13) is  
5 displaceable by the movement of the furnace.

1           8. The casting device according to one of claims 5 to 7  
2 characterized in that the immersion tube (13) is arranged with an  
3 inclination relative to the longitudinal axis of the casting gap  
4 and is displaceable.